

30

Date:
User:Monday, 7/9/2007 12:46:41 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 A/B STEP ASSEMBLY
 Job Number : 33411
 Estimate Number : 10849
 P.O. Number : *N/A*
 This Issue : 7/9/2007 S.O. No. : *N/A*
 Prsht Rev. : NC Part Number : D206628011
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 33038 Drawing Revision : N/A
 Material : *N/A*
 Due Date : 7/27/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : *7/07.07.09*
 Comment : Est Rev.D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-011 CHG 002

7/07.07.09

2.0 33411A 206B STEP ASSY, LH



Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2721-041 B

*33411A**CV*

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D27313 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

2 D2731-3 Mounting Lug

Batch

*1527781**52**SP**30994**3x*

5.0 D27317 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description

2 D2731-7 Mounting Lug

Batch

*33728**33665**7/7/30 SP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 33411

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 1.1708 f(s)/Unit Total : 3.5123 f(s)

Pick :

Qty Part # Description Batch
2 D2856-400 6.9" Abrasion Strip

1332992 ✓

SP

7.0

D2856400

Abrasion Strip



Comment: Qty.: 0.5460 f(s)/Unit Total : 1.6380 f(s)

Pick :

Qty Part # Description Batch
2 D2856-400 6.25" Abrasion Strip

1332992 ✓

SP

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-041 LUG ASS,Y

1330997 ✓

SP

9.0

D3394043

LUG ASS'Y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3394-043 LUG ASS,Y

1330998 ✓

SP

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4-15A Bolt

1104072 ✓

SP

11.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 AN4-11A Bolt

1102280 ✓

7/3/30 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B STEP ASSEMBLY

Job Number: 33411

Part Number: D206628011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4-12A

Bolt

1104547

SC

13.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

11

12 AN960JD416

Washer

1104215

SC

14.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

11

12 MS21042L4

Nut (or MS21042-4)

1102552

7/7/30 SC

(3)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-028-011

Location:

PPP Rev:

12

07/8/3

(3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



07-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

30

Date: Monday, 7/9/2007 12:46:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B STEP ASSY, LH
 Job Number : 33411A
 Estimate Number : 11698
 P.O. Number : *N/A*
 This Issue : 7/9/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 33038A
 Part Number : D2721041
 Drawing Number : D2721 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 7/27/2007 Qty: 3 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>532858</i>

Check Material for any Dents or Defects

Q.11 07.07.19

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2721-1 using D2622 extrusion as per Dwg D2721
 Deburr and bevel ends for welding

07.07.19
Q.11 07.07.19

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>330883</i>

Q.E. 07.07.19

4.0 D34611 PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

206 Step Lug

Pick:

Qty	Part Number	Description	Batch
1	D3461-1	Plate	<i>333070</i>

Q.E. 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:46:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 33411A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34613

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description

1 D3461-3 Plate

Batch

333071

PE. 07.07.19 3

6.0

D34615

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description

1 D3461-5 Plate

Batch

333072

PE. 07.07.19 3

7.0

D34617

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description

1 D3461-7 Plate

Batch

333073

PE. 07.07.19 3

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod

Batch:

104721
M103794

Grind end cap welds flush

PE. 07.07.20 3

PE. 07.07.20 3

Q.M. 07.07.24

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

15/07/24 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:46:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 33411A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ed 07/07/24

(X3LH)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07.07.24

3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ed 07.07.25 3

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2721 using Jig DT

followed by Jig DT

A/R AL Rod Batch: MIC3794
MIC4721

Grind End Cap Welds Flush

Q.M 07.07.24

Ed 07.07.25 3

Ed 07.07.25 3

Ed 07.07.25 3

3

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Ed 07-07-26 (3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ed 07/07/26 (X3LH)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Alodine

M. H

07/08/02

(3X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/14/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 12:46:47 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B STEP ASSY, LH

Job Number: 33411A

Part Number: D2721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



M 105068



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BK

07-08-02

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(3X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l

07/08/02

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M104942



(3X)

Comment: Wing Walk as per Dwg D2721 and QSI 00 5 4.4

m-l

07/08/02

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/7/03

(3)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ADD 33411

6/7/03

22.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



07-08-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

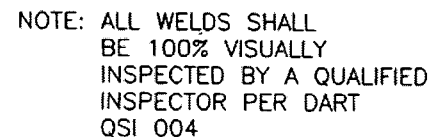
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

Diagram of the D2734 End Plate. The plate is shown with a vertical dimension of 1.000 and a horizontal dimension of 45.0°. The plate is labeled D2734 END PLATE.

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL

RELEASED
05.11.14 ~~AK~~

DART

DESIGN	PH	UNKN KN	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	AK	APPROVED	AK	DRAWING NO. D2721
DATE	05.09.19		TITLE	SHEET 1 OF 1
A	97.12.04	NEW ISSUE		SCALE NTS
B	98.10.19	79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7		

Date: Friday, 07/09/2007 1:11:06 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-628
Job Number : 34468	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 07/09/2007 S.O. No. : N/A	Drawing Number : ECN 1029
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 14/09/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK - ADD NEW PAPERWORK PER ECN 1029

EASA STC: EASA.IM.R.S.01339:

D206-628-011

33411 (3X)

33038 (4X)

32979 (1X)

D206-628-012

32980 (1X)

33892 (1X)

D206-628-013

D206-628-014

18533 (1X) 18943 (1X)

D206-628-021

31976 (3X)

33756 (3X)

29739 (1X)

D206-628-021BL

33649 (2X)

D206-628-022

33757 - 31977 (3X)

D206-628-023

33921 (1X)

D206-628-024

33922 (1X)

D206-628-031

31010 (4X)

D206-628-032

29738 (1X)

31011 (4X)

D206-628-033

30806 (2X)

31241 (2X)

D206-628-034

30807 (2X)

4/8/11 SP

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-628-011

Job Number : 37221

Estimate Number : 10804

P.O. Number :

Part Number : D206628011

This Issue : 05/02/2008 S.O. No. :

Drawing Number : ECN 1118

Prsht Rev. : NC

Project Number :

First Issue : // Type : LARGE FAB ASSY

Drawing Revision :

Previous Run : 00015

Material :

Written By : _____

Due Date : 12/02/2008 Qty: 16 Um: Each

Checked & Approved By : _____

Comment : _____

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
PULL FROM STOCK

D206-628-011 CHG002 4x B33038 3x B33411

33411 X3

33038 3x

R 6

2.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
ADD NEW PARTS TO KIT PER ECN 1118*** NEW RED AND WHITE LABELS REQUIRED FOR
NEW CHANGE NUMBER *** CHG0038x D2732 RUBBER EXTRUSION
CUT 3.00" LONG B 37717

4x AN4-13A BOLT B M105615

4x AN4-14A BOLT B M105615

3.0

D2732

Rubber Extrusion

Comment: Qty.: 2.0000 f(s)/Unit Total: 14.0000 f(s)
Rubber Extrusion B 37717

R

R 6

Date: Friday, 18/04/2008 7:50:09 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-628-UPDATE PAPERWORK
Job Number	: 38685		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 18/04/2008 S.O. No. :	Drawing Number	: ECN1126
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 25/04/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

D206-628-011

33038

(3x)

33411

(3x)

D206-628-012

33892

(1x)

33412

(1x)

D206-628-013

36963

(4x)

36078

(1x)

D206-628-014

36961

(6x)

D206-628-021

31974

(1x)

34980

(1x)

33756

(2x)

D206-628-022

33757

(1x)

34981

(3x)

D206-628-023

36492

(1x)

34575

(2x)

D206-628-024

36493

(1x)

34576

(3x)

D206-628-031

31010

(4x)

D206-628-032

31011

(4x)

D206-628-033

D206-628-034

ADD NEW PAPERWORK TO KITS IN STOCK
DSI 9332, PER ECN 1126

8/4/24 500